

Work Order ID 132154

Wednesday, April 29, 2015 9:10:55 AM

132154

Page 1

Item ID: D1048

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp

Start Date: 4/29/15 Start Qty: 24.00

24

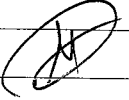
Cust Item ID:

Required Date: 5/01/15 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan:  Date: 5-4-29

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D1048	Rev A								

100

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D1048

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

0.00

(28)

DC 15/04/29

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

(28)

DC 15/04/29

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

(28)

DAS

38

9-89

APR 29 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval																																																							
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Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.								
140		0.01							
140	NC BRAKE								
Brake NC	Memo	0.04							
Brake NC	Form as per dwg D2010 using DT8053 using AT10143								
150		0.00							
150	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

DAS
36
9-89

DAS
36
9-89

DAS
38
9-89

APR 30 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
160	<i>M 123480</i>					<i>29</i>	<i>0</i>	<i>15-5-5</i>	<i>28 38</i>
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>9:05</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>9:35</i>								
170	QC3- Inspect Part Finish	0.00							DAS 38 9-89
170									
QC	Memo	0.00							
Quality Control									(29) DAS 28 9-89 MAY 05 2015
180	Identify as per dwg & Stock Location: <i>GA</i>	0.00							
180									
Packaging	Memo	0.00							
Packaging									<i>29</i> DAS 27 9-89 MAY 05 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 132154***132154***

Page 4

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

ML5 MAY 05 2015

MF
15-5-5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, April 29, 2015 9:11:00 AM

Page 1

Work Order ID: 132154

132154

Parent Item: D1048

D1048

Parent Item Name: Clamp

Start Date: 4/29/15

Required Date: 5/01/15

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP: B02.02.22Re-formatNG
IPP Rev:C Now on Waterjet 06-12-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased				100	sf	352.4176	0.018	1			
M304S16GA									**				
304/316 Sheet .063													

22 15/04/29

Location

Loc Qty

Loc Code

MAT019

352.4176

m131384

138.6176

m131503

213.8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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PAR 15.49	
PAR 15.04.28	D
2.175	
1.755	

☒ **First Article** ☐ **Prototype**

2.175
1.755

DAS
38
9-89

sed by
D *[Signature]*

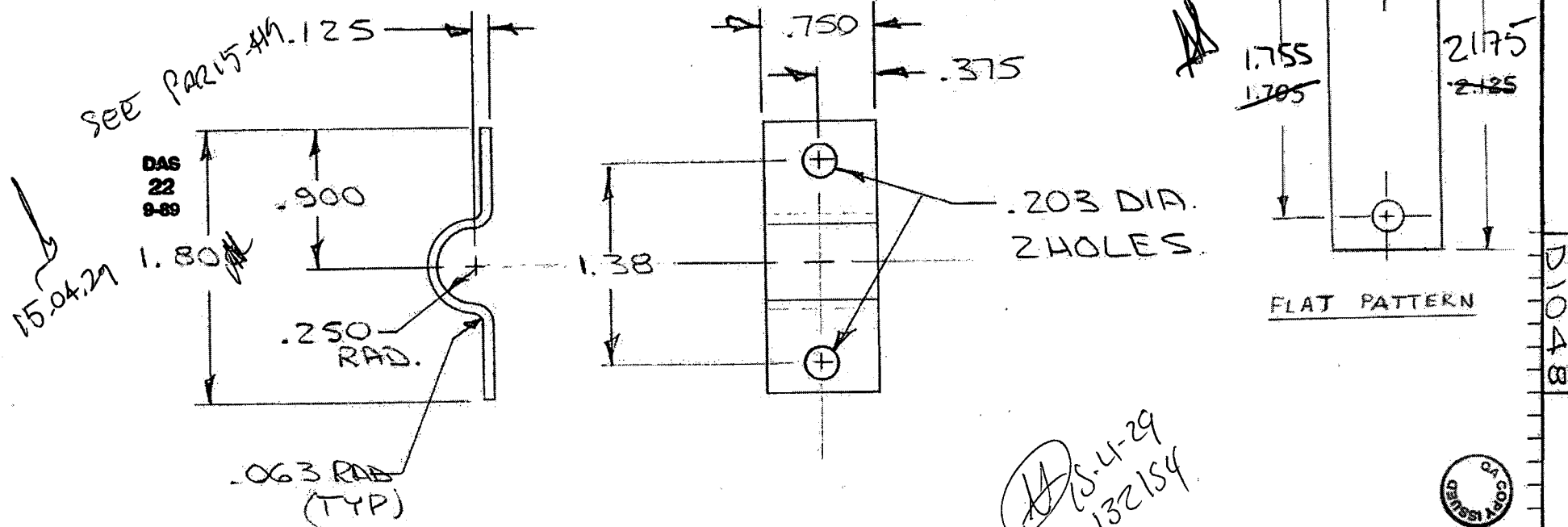
NOTES:

1) MATERIAL

STAINLESS STEEL
T304#2B .062 THICK

2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)
PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020



A		REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.		ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR
RF		DRAWN			BASIC CODE		CONTRACT NO.		DATE		DART AERO ACCESSORIES INC. VANCOUVER CANADA	
C		APPROVED			D-DIMPLE C-COUNTERSINK		DIA. DASH NO. W-HEAD NEAR SIDE F-HEAD FAR SIDE		DRAWN BRADLEY		DESIGN BRADLEY	
01.12.05 ADD FLAT PATTERN		DESCRIPTION OF CHANGE	REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		BASIC CODES		LENGTH DASH NO. W-SPOTWELD		STRESS		TITLE CLAMP	
			GENERAL		BASIC CODES				CHECKED		CODE	
			LIMITS		BASIC CODES				CUT		DWG NO. D1048	
			1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - 5 - 7743 5. HOLES PER AND 10387		1. TOLERANCES - .001 & .002 2. ANGLES - 1/2" & 1/4" 3. PARALLELISM - .0025 4. SYMMETRY ABOUT ALL M/C CENTRE LINES .005		8-MS20470AD 8-MS20470AD				SCALE 1:1	
			REPORT ALL DISCREPANCIES - DO NOT SCALE								REV. A	